

Standards:

EN ISO 3581-A: E 25 4 R 32
 EN 1600: E 25 4 R 32
 Mat.-No.: 1.4820

capilla® 4820**Recovery:****120%****Product description:**

Rutile-basic coated stick electrode suitable for cladding and fusion welding of similar alloyed 25%-Cr-steels.

Scaling resistant in oxidising fume gases up to 1150°C.

Very resistant to sulphuric gases at elevated temperatures

Applications:

Suitable for cladding and fusion welding of corrosion and scaling resistant 25%-Cr-steels without Mo.

The weld deposit is corrosion resistant like similar alloyed duplex stainless steels.

Base materials:

1.4340, 1.4347, 1.4821.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Fe
Min.	0,05	25	4,5	
Max.	0,08	26	5,5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	700	[MPa]
Yield strength $R_{p0,2}$:	500	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Hardness:	180	[HB 30]

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	300	40 – 60	= (+)
2,5	300	60 – 90	
3,25	350	80 – 110	
4,0	350	100 – 150	
5,0	450	150 – 200	

also available:

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Capilla 4820 MAG

Capilla 4820 WIG